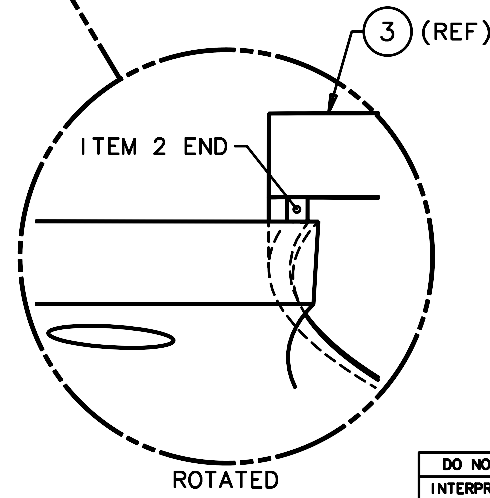
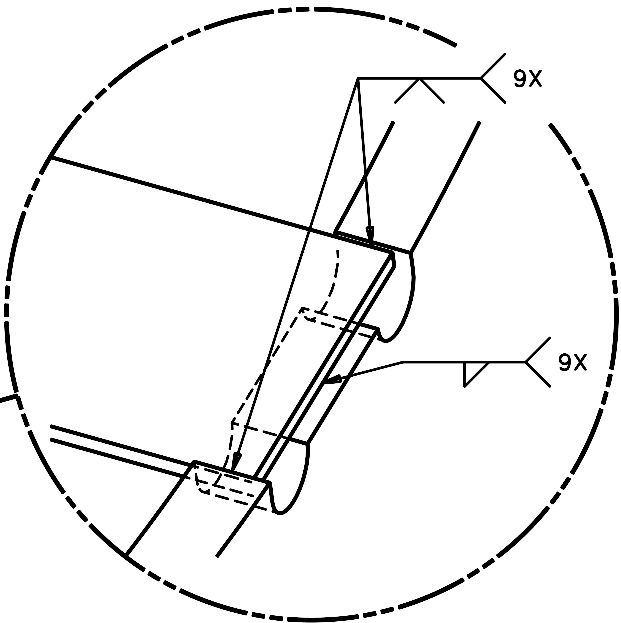
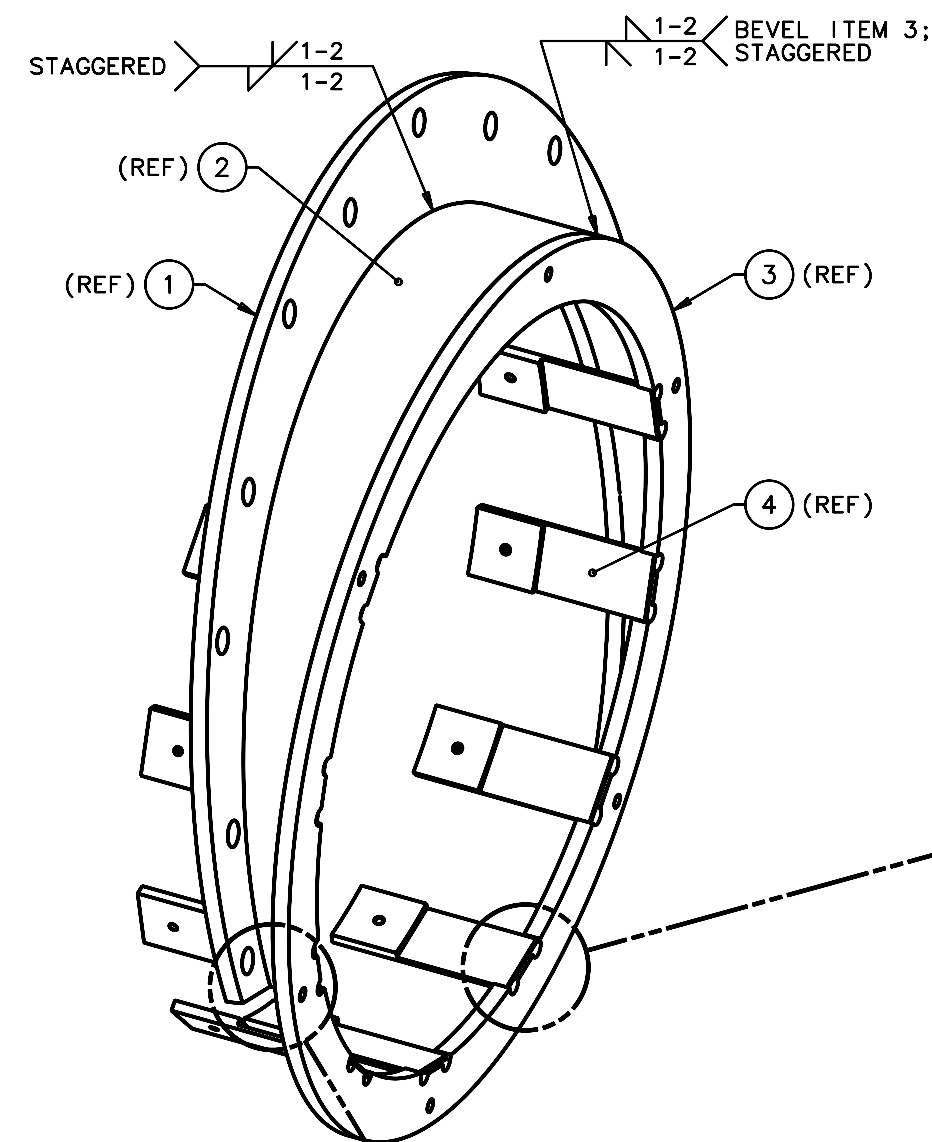
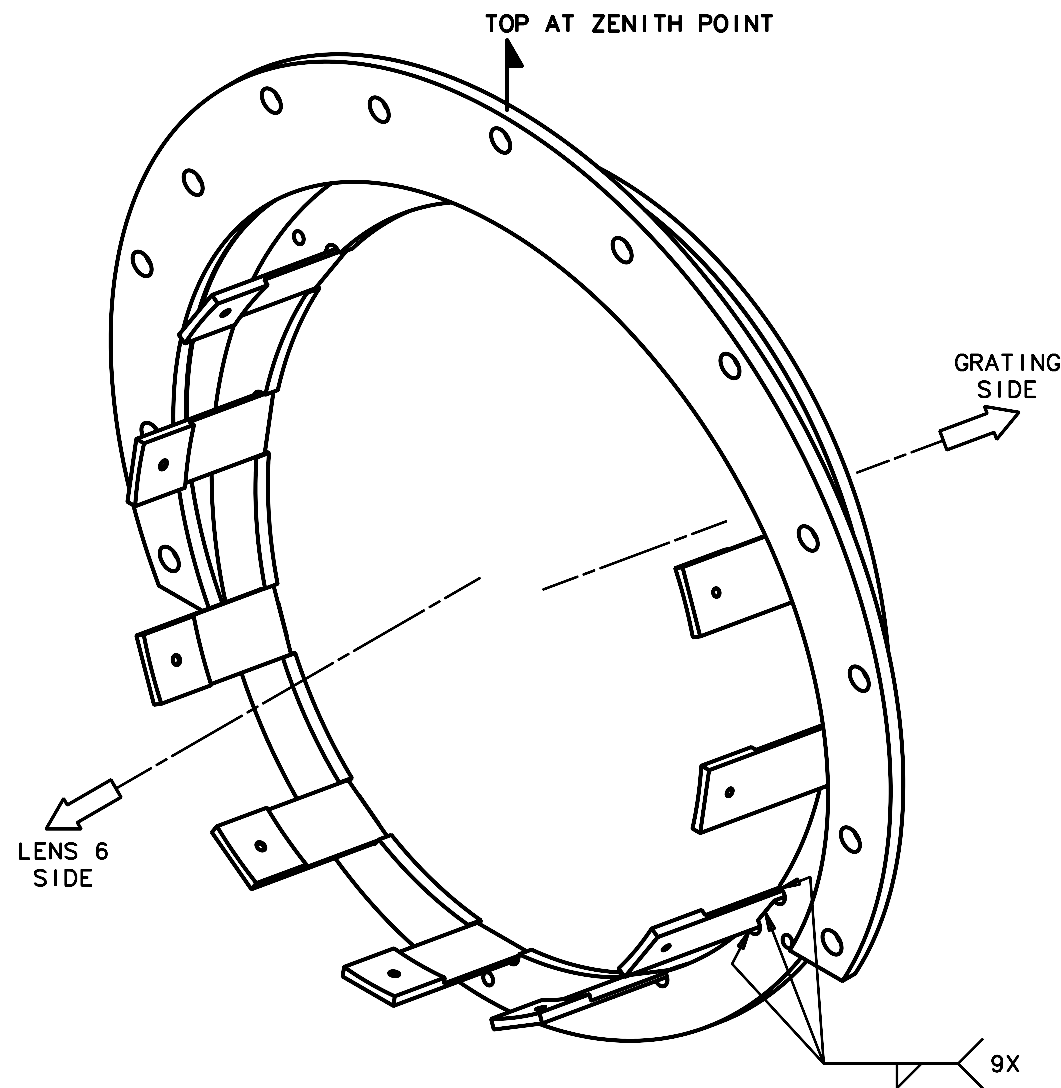


REVISIONS				
LTR	DESCRIPTION	DATE	REVISED BY	APPROVED
A	INITIAL RELEASE	8/2/04	R. NAGY	B. CUERDEN
B	ADDED NOTE 7; NOTE 8 WAS PART OF VIEW A-A; ITEM 4, SHT 4; 1.00, 2.89 WAS 1.000, 2.888	9/8/04	R. NAGY	B. CUERDEN
C	SHTs 1-4 ONLY (SHTs 5, 6 REMAIN AT REV B); INCORPORATED ECO 035; THIS SHT: UPDATED VIEWS PER ECO	2/14/05	R. NAGY	M. REED



**ISO VIEWS**

SCALE NTS  
ADDITIONAL FABRICATION VIEWS ON SHTs 2 THRU 6

**NOTES:**

1. BREAK SHARP EDGES & DEBURR.
2. MACHINED SURFACE FINISH TO BE 125 RMS OR BETTER.
3. ALL WELDS TO BE GAS TUNGSTEN ARC WELDING (GTAW) WITH INVAR FILLER ROD.
4. HEAT TREATMENT:
  - A. HEAT TREAT AT 315°C FOR 60 MINUTES IN AIR.
  - B. COOL TO ROOM TEMPERATURE IN AIR.
  - C. HOLD AT 95°C FOR 49 HOURS IN AIR.
  - D. COOL TO ROOM TEMPERATURE IN AIR.
5. ZINC CHROMATE PER ASTM-B-633-98, TYPE II, BLACK.  
PLUG ALL THREADED HOLES. ALSO MASK-OFF NOTED SURFACES & PLUG HOLES OF ITEM 4 FINGERS (SIDE VIEW, SHT 2).
6. DIMENSIONS ARE BEFORE ZINC CHROMATE.
7. EXCEPT FOR NORMAL SPRING ACTION OF ITEM 4 FINGERS, DO NOT BEND FINGERS WHEN WELDING, MACHINING, SHIPPING, ETC.
8. EDM ITEM 4 FINGERS TO INSIDE DIAMETER NOTED PER VIEW A-A (SHT 3).

QTY PER ASSY	-3	-2	-1	PART NUMBER	PART DESCRIPTION	MANUFACTURER of MAT'L SPEC	ITEM NO.
	9			-4	FLEXURE FINGER		4
	1			-3	FLEXURE FINGER PLATE		3
	1			-2	COVER RING		2
	1			-1	BASE PLATE		1

**LIST OF MATERIALS**

DO NOT SCALE DRAWING  
INTERPRET DIMENSIONS AND TOLERANCES IN ACCORDANCE WITH ASME Y14.5M-94

TOLERANCES UNLESS OTHERWISE SPECIFIED  
LINEAR: .1 = NA, .01 = ±.03, .001 = ±.010  
ANGULAR: 1°  
DIAMETRICAL: SEE SPEC S-002

MATERIAL: INVAR 36 ALLOY  
FINISH: 5

THIS DRAWING CREATED IN:  
ACAD  MECH  IDEAS

DESIGNED BY: B. CUERDEN/D. DEAN  
DRAWN BY: R. NAGY  
CHECKED BY: G. LANDIS  
APPROVED BY: B. CUERDEN, M. REED, J. BECHTOLD

DATE: 3/5/04  
3/11/04  
7/26/04  
8/2/04  
8/2/04

933 N. Cherry Avenue, Tucson, AZ 85721 (520)621-7659  
CATEGORY: MMT  
PROJECT: MAESTRO  
TITLE: PRISM CELL PRISM FLEXURE RING WELDMENT

13285 MMT  
NEXT ASSY USED ON

ASSEMBLY APPLICATION

STEWART OBSERVATORY, UNIVERSITY OF ARIZONA

PLOT SIZE SCALE: D -  
DRAWING NUMBER: 13288  
REVISION: C

CURRENT TIME/DATE/FILE LOCATION:  
DRAWING ARCHIVE LOCATION: http://dovinci.es.arizona.edu/ecad/default.html

SHEET 1 OF 6